

Date: Wednesday, 02/04/2008 11:27:30 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET
Job Number :	38296		
Estimate Number :	12840		
P.O. Number :		Part Number :	D35421
This Issue :	02/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3542 REV A
First Issue :	//	Project Number :	N/A
Previous Run :	34221	Drawing Revision :	A
	Type :	Material :	
	MACHINED PARTS	Due Date :	16/04/2008
Written By :		Qty:	20
		Um:	Each
Checked & Approved By :	JLD 08.4.08		
Comment :	Est Rev: A New Issue 07-04-23 JLM Est Rev: B updated powder coat per NCR 07.05.16 EC		

*Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B3000X01500	6061-T6 Bar 3" x 1.5"
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Comment: Qty.: 0.3500 f(s)/Unit Total: 6.9993 f(s)

6061-T6 Bar 3" x 1.5"

BATCH: M16530

ml 08/04/08 21

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 4.0" long

ml 08/04/08 21

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA684 Rev: AA & Dwg D3542 Rev: A

2-Deburr per dwg D3443

H.A. ml 08/04/08

(21)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A. ml 08/04/08 (21)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

H.A. ml 08.4.08 21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 11:27:30 AM
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 38296

Part Number: D35421

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(21)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 08-04-14.

7.0

POWDER COATING

POWDER COATING



m 106442

Comment: POWDER COATING

Powder Coat Grey sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*****ENSURE TO MASK INSIDE BORE*****

FL 08/04/15

(21)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(21)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-04-15

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 243A

8/4/15

SD

(21X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/17

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



cmf 08-04-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

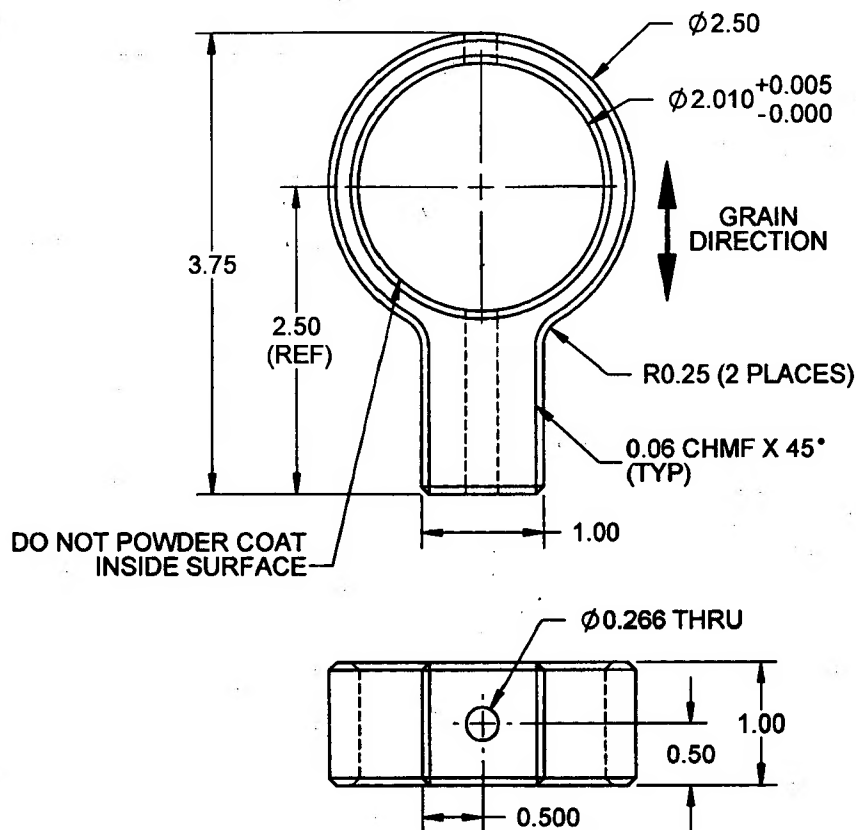
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

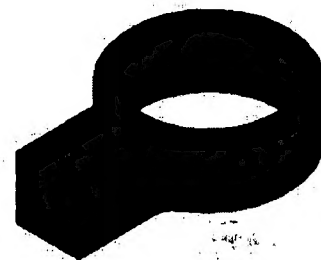
NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3542	REV. A SHEET 1 OF 1
DATE 06.11.27	TITLE BRACKET		SCALE 2:3
REV A	DATE 06.11.27	DESCRIPTION NEW ISSUE	

RELEASED
07.04.02

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38296

D3542-1 BRACKET**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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